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54 **Poly(arylene sulfide) resin ternary blends.**

57 A ternary polymer alloy containing a poly(arylene sulfide), a poly(amide imide), and at least one of a poly(aryl ketone) and a poly(aryl sulfone). The polymer alloy optionally can contain a fibrous reinforcing material such as a glass fiber.

EP 0 241 019 A2

POLY(ARYLENE SULFIDE) RESIN TERNARY BLENDS

Field of the Invention

The invention relates to poly(arylene sulfide) resin ternary blends. The invention further pertains to polymer (blends) containing a poly(arylene sulfide) resin, a poly(amide imide), and at least one of a poly(aryl ketone) and a poly(aryl sulfone). The invention also relates to such polymer alloys further containing fiber reinforcing materials.

Background of the Invention

Poly(arylene sulfide) is a unique class of materials, produced commercially, that have found application in a variety of areas. Poly(arylene sulfide)s are resistant to most chemicals, have relatively high melting temperatures, and have good dimensional stability, as compared to other thermoplastics.

For certain some thermoplastic applications, alloys of two or more resins may exhibit a better balance of properties. For example, by admixing a resin having certain desirable physical properties with a second and/or third resin having other desirable physical properties it is hoped to find resin blends that have inherited at least some of the desired physical properties from each of the resins. Frequently, this has not been the case. But, the search has continued for blends (alloys) of improved properties.

It is an object of our invention to provide polymer alloys containing a poly(arylene sulfide)s and certain additional resins. It is also an object of our invention to desirably modify one or more physical properties, such as flexural strength, tensile strength, elongation, impact resistance, and heat distortion temperature, of the poly(arylene sulfide)s.

Summary of the Invention

According to our invention, a polymer alloy is provided containing a poly(arylene sulfide), a poly(amide-imide), and at least one of a poly(aryl ketone) and a poly(aryl sulfone). Our invention further provides such polymer alloys containing a fiber reinforcing material. Various fillers and colorants also can be used. The polymer alloys are useful in preparing articles of manufacture since the blended resins exhibit desirable physical properties when compared to the individual resins.

Detailed Description of the Invention

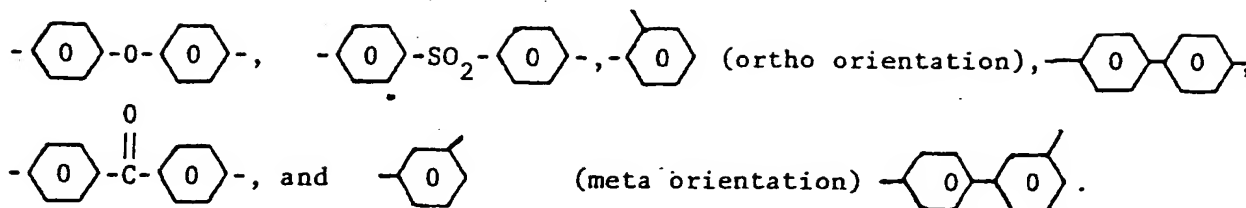
Poly(Arylene Sulfide)s

The poly(arylene sulfide)s resins include any polymeric material formed predominately by one or more aryl moieties having connecting sulfur linkages. Such polymers include those represented by the formula $(-R-S-)_n$ wherein R is a substituted or unsubstituted phenylene radical and n is at least 50. Suitable starting materials and preparative methods are disclosed in such as U.S. Patents 3,354,129 and 3,919,177, the disclosures of which are hereby incorporated by reference.

Typically, a polyhalosubstituted aromatic compound is reacted with a sulfur source in a polar organic compound. In a commercial form of this process, paradichlorobenzene, optimally with a minor amount of a trichlorobenzene, is reacted with sodium sulfide in N-methyl-2-pyrrolidone, generally further in the presence of a small amount of an alkali metal carboxylate.

Suitable polyhalosubstituted aromatic compounds for producing poly(arylene sulfide) polymers and copolymers include 1,2-dichlorobenzene, 1,3-dichlorobenzene, 1,4-dichlorobenzene, 2,5-dichlorotoluene, 1,4-dibromobenzene, 2,5-dibromoaniline, 1,2,4-trichlorobenzene, 1,3,5-trichlorobenzene, and the like, and mixtures thereof.

The poly(arylene sulfide)s can be a copolymer of two or more aromatic monomers. Referring to the general $(-R-S-)_n$ formula above, the predominate R group in a copolymer generally will be p-phenylene with, usually relatively minor amounts of, for example, aryl moieties such as



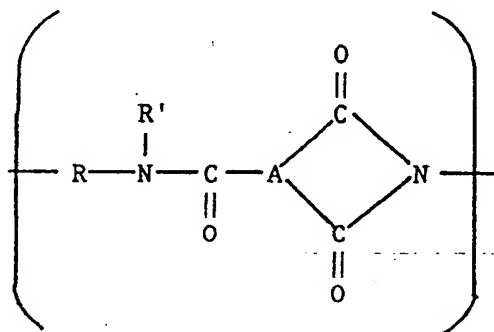
10 The preferred copolymers are those in which at least about 90 percent of the aromatic units are unsubstituted monoaromatic units. The linkages for the aromatic units also can include functionalities in addition to sulfide,

for example $\text{---} \text{C}(=\text{O}) \text{---}$ and/or $\text{---} \text{O} \text{---}$.

15 The presently preferred polymers in terms of availability and properties are poly(phenylene sulfide)s, which contain an unsubstituted benzene ring. Poly(phenylene sulfide) resins in general are thermoplastic polymers having a melting point in the range of about 280° to about 290°C, and are available as Ryton® poly(phenylene sulfide)s in various forms as a product of Phillips Petroleum Company.

20 Poly(amide imide)s

The poly(amide imide) resins can be characterized by having both an amido radical and an imido radical in the repeating structure and can be represented by a repeating unit of the general formula:



in which A represents a trivalent aromatic group containing at least one 6-membered carbon ring in which two carbonyl groups are bonded to adjacent carbon atoms of the benzene ring in the A group; R is a divalent aromatic or aliphatic residue; and R' is a hydrogen, methyl, or phenylene group.

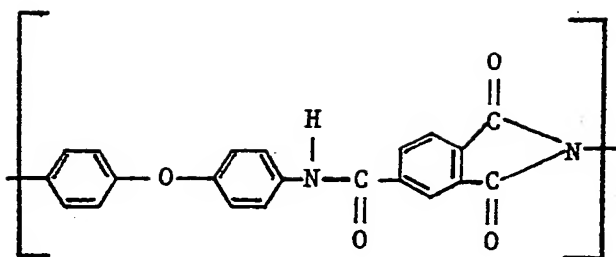
Processes for preparing poly(amide imide) resins are disclosed in, for example, U.S. Patents 3,661,832, 3,669,937, and 4,139,576, the disclosures of which are incorporated herein by reference. The poly(amide imide) resins can be prepared, for example, by reacting an excess diamine with diacid dichloride to form low-molecular weight amine-capped polyamide which is then reacted with pyromellitic dianhydride in dimethyl acetamide to form a poly(amide-(amide-acid)). The reaction mixtures are cast into poly((amide-acid)) film, which is subsequently converted to an aromatic poly(amide-imide) resin.

Another method for preparing the aromatic polyamide-imides involves the reaction of trimellitic anhydride derivatives, such as acid halide or acid ester, with a diamine. The poly(amide-(amide-acid)) is formed, which upon conversion, yields the poly(amide imide).

50 The preferred poly(amide-imide) resins are commercially available from Amoco Chemicals under the tradename, Torlon 4203E®, which is represented by repeating units of the following molecular structure:

5

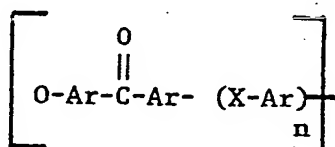
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Poly(Aryl Ketone)s

15

Poly(aryl ketone)s suitable for use in our ternary blends can be shown by the following formula:

20

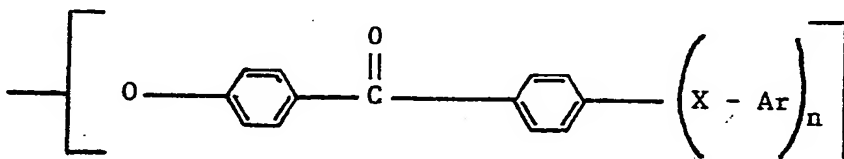


in which Ar is independently a divalent aromatic radical selected from phenylene, biphenylene, or naphthylene;

25 X is independently O, $\text{C}=\text{O}$, or a direct bond; and n is 0 or an integer of 1 to about 3.

Preferably, the poly(aryl ketone)s contain repeating units represented by the following formula:

30

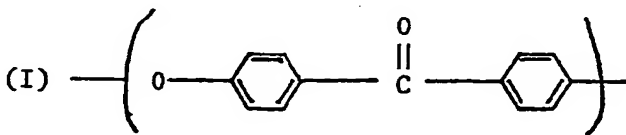


in which Ar, X, and n are as described above.

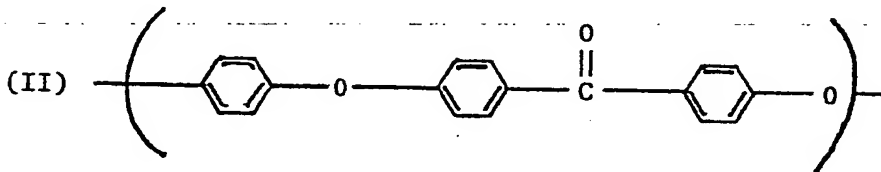
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The most preferred poly(aryl ketone)s have repeating units of the formula:

40



45



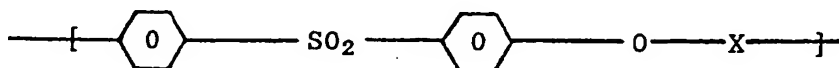
50 Poly(aryl ketone)s can be prepared by methods known in the art, such as by heating a substantially equimolar mixture of at least one bisphenol and at least one dihalobenzoid compound or at least one halophenol compound. The poly(aryl ketone)s can be prepared by processes as described in U.S. patents 4,176,222 and 3,953,400, the disclosures of which are hereby incorporated by reference.

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Poly(Aryl Sulfone)s

The aromatic polysulfones are high molecular weight polymers containing sulfone groups and aromatic nuclei in the main polymer chain.

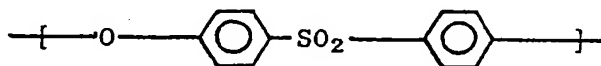
Poly(aryl sulfone)s suitable for use in our ternary blends can be represented by repeating units of the formula:



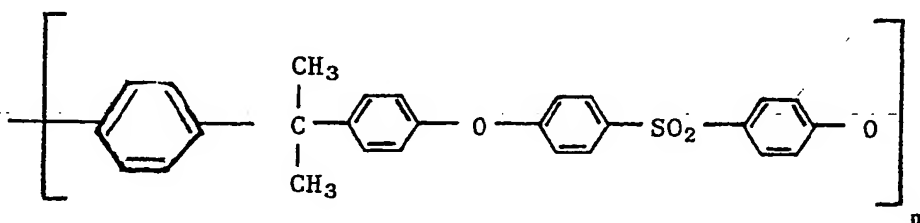
in which X is a substituted or non-substituted aryl group such as aryl ether, aryl sulfide, aryl ketone, or aryl sulfone. The poly(aryl sulfone)s are represented by aromatic rings linked alternately by ether and sulfone groups.

The poly(aryl sulfone)s can be prepared in a polymerization step wherein sulfone links are formed by the reaction of an aromatic sulfonyl chloride with a second aromatic ring. The development of sulfonylation as a polymerization process was accomplished by using catalytic amounts of certain halides, e.g., FeCl_3 , SbCl_5 , and InCl_3 . A process for preparing poly(aryl sulfone)s is disclosed for example in U.S. patent 3,838,097, the disclosure of which is hereby incorporated by reference.

A preferred poly(aryl sulfone), in terms of its availability and properties, is polyether sulfone, such as sold by Imperial Chemical Industries Ltd., under the tradename Victrex®, and which can be represented by repeating units:



Another preferred aromatic polysulfone is prepared using 2,2-bis(4-hydroxy-phenyl)propane (Bisphenol A). Such an aromatic polysulfone, commercially available from Union Carbide Corp. under the tradenames Udel P-1700® and Udel P-3500®, can be represented by:



in which m has a value in the range of about 50 to 80.

Another suitable aromatic polysulfone that can be employed in our invention is the copolymeric polysulfone of the type described in U.S. Patent No. 3,321,449, the disclosure of which is incorporated herein by reference. A copolymeric polysulfone is sold under the tradename, Astrel 360®, by the Minnesota Mining and Manufacturing Co. This copolymeric polysulfone is characterized as one containing biphenyl and phenyl units linked by oxygen or sulfone units.

Preparation

The blends (alloys) of our invention can be prepared using conventional techniques known in the art for producing such unitary masses from two or more resins. For example, the alloys can be formed by mixing suitable amounts or proportions of the dry powders or pellets of each of the resins by tumbling, followed by further mixing in a suitable polymer compounding device such as an extruder for melt extrusion. The mixing that takes place during conventional injection molding also will suffice to produce the alloys. Other known methods of forming alloys of resins which can be employed include for example melt mixing in a Banbury mixer. To form the alloys, the temperature has to be at least high enough that the resins employed melt, but the temperature should be kept sufficiently low to insure that none of the resins will be degraded. The resulting alloys can be granulated or pelletized if desired for convenience in handling for subsequent molding operations.

The amounts of each of the above-mentioned polymers in our polymer alloys can vary over a wide range, depending on desired properties. The ratios of the three or four polymer components in our alloys should be that which is effective to desirably modify one or more physical properties of the poly(arylene sulfide)s.

5 Generally, the polymer alloys will contain about 10 to 90 weight percent, preferably about 45 to 80 weight percent, most preferably about 45 to 50 weight percent poly(arylene sulfide), based on the weight of the blend composition excluding other compounding components such as fillers, colorants, and fibers.

The polymer alloys can contain a suggested range of about 5 to 50, preferably 10 to 40, weight percent of the poly(amide imide) resin, on the same basis.

10 The ternary blends can contain about 5 to 80 weight percent, preferably about 10 to 40 weight percent, of at least one of a poly(aryl ketone) and a poly(aryl sulfone), on the same basis.

It is realized that the total calculated percentages extend beyond 100, but that in practice the amounts of each component are readily proportioned to total 100, again excluding other compounding components.

Our alloy compositions optionally can include a reinforcing material such as glass or carbon fibers. 15 When used, such materials generally will make up about 10 to 50 weight percent, preferably about 20 to 50 weight percent, and more preferably about 25 to 45 weight percent, based on the total weight of the polymers in the alloy compositions.

The alloy compositions optionally can include filler materials, such as calcium carbonate and calcium sulfate. Suitable amounts of filler vary widely, but generally will be from 0 to 50 weight percent, preferably 20 about 0.5 to 20 weight percent, based on the total weight of the polymers in the composition.

The blend compositions can contain additional optional components such as mold corrosion inhibitors, pigments, processing aids, and the like.

The compositions (alloys) are useful in preparing any articles of manufacture based on the poly(arylene sulfide) resins. The alloys are particularly useful where improved HDT (heat deflection temperature) 25 properties are important.

Examples

30 Examples provided are intended to assist in a further understanding of our invention. Particular materials employed, species, conditions, are intended to be further illustrative of our invention and not limitative of the reasonable scope thereof.

The examples show that blends of poly(phenylene sulfide), poly ether ether ketone, and poly (amide imide) improve such properties as tensile strength and flexural strength when compared to an alloy 35 containing poly(phenylene sulfide) and poly ether ether ketone.

Each poly(phenylene sulfide) polymer used in the examples was prepared according to the method of U.S. Patent Number 4,038,262 by reacting dichlorobenzene and sodium sulfide in N-methyl-pyrrolidone containing 1, 2, 4-trichlorobenzene and sodium acetate, and recovering the product. The flow rate was determined in accordance with the procedure described in ASTM D 1238-70 at 316°C (600°F) using a 5 kg. 40 weight and is reported in grams per 10 minutes. The poly(phenylene sulfide) employed is known under the trademark RYTON and was obtained from Phillips Petroleum Company.

Example I

45 A series of homogeneous physical blends was prepared by mixing a poly(phenylene sulfide) (PPS) powder having a flow rate of 50, with poly ether ether ketone (PEEK) pellets having a melting point of 334°C, and polyether sulfone (PES) pellets having a specific gravity of 1.37. The PEEK was obtained from Imperial Chemical Industries. The PES was obtained from Imperial Chemical Industries under the trademark 50 Victrex P300. Each polymer was dried for two hours at 150°C in the presence of air. The appropriate weight of each polymer was placed in a plastic bag and the contents were thoroughly mixed. Each weighed blend of polymers was extruded at 349°C (660°F) from a Davis Standard 1-1/2 inch extruder to form granules after chopping the extrudate. Test specimens of each blend were prepared by injection molding. The test specimens were annealed for two hours at 204°C. The results of physical tests on the annealed specimens 55 are presented in Table I:

Table I

Run No.	1	2	3	4	5	6	7	8	9	10	11
PPS, Wt. %	100	80	50	50	50	45	33.3	0	0	50	50
PEEK, Wt. %	0	10	40	35	25	10	33.3	100	0	50	0
PES, Wt. %	0	10	10	15	25	45	33.3	0	100	0	50
Heat Distortion Temp, °F ^a	117	143	165	165	185	201	177	164	201	154	212
Flexural Modulus, MPa ^b	3455	3523	3786	3650	3367	3336	3483	3499	2560	3748	3448
Flexural Strength, MPa ^c	148	127	165	164	162	160	140	164	130	166	77
Tensile Strength Break, MPa ^d	85.6	86.9	99.2	100.2	94.6	90.3	93.4	107	61.6	97.5	50.2
Elongation, % ^e	3.4	2.3	3.9	3.5	5.4	3.0	4.6	39.2	8.6	9.0	1.4
Izod Impact, J/M ^f	44.2	45.4	32.5	30.9	50.0	48.0	47.6	61.2	93	44.8	25.5
inch of notch											
Izod Impact, no notch ^g	293	287	632	796	905	1013	548	3756	2966	1096	85.3
J/M											

^a Heat distortion temperature, D648.^b ASTM D790.^c ASTM D790.^d ASTM D638.^e ASTM D638.^f ASTM D256.^g ASTM D256.

The data in Table I show that the homogeneous ternary blends (Runs 2-7) have a higher heat distortion temperature than the original PPS (Run 1). The data show that homogeneous ternary blends (Runs 3-7) have a higher heat distortion temperature than the original PEEK (Run 8) and the 50/50 weight percent of PPS and PEEK (Run 10). The heat distortion temperature of the ternary blends (Runs 2-7) increases as the percentage of PES in the ternary blends is increased.

The data show that the homogeneous ternary blends (Runs 3-6) have greater flexural strength than the original PPS (Run 1), original PES (Run 9), and a 50/50 weight percent of PPS and PES (Run 11). The data show that the homogeneous ternary blends (Runs 2, 3, 4 and 7) have greater flexural modulus than the original PPS (Run 1) and the 50/50 weight percent of PPS and PES. The data further show that the homogeneous ternary blends (Runs 2-7) have a greater flexural modulus than the original PES (Run 9).

The data show that ternary blends (Runs 2-7) have greater tensile strength than the original PPS (Run 1), original PES (Run 9), and a 50/50 weight percent of PPS and PES (Run 11). The data show that ternary blends (Runs 2, 5, 6 and 7) have greater Izod Impact values than original PPS (Run 1), a 50/50 weight percent of PPS and PEEK (Run 10), and a 50/50 weight percent of PPS and PES (Run 11).

Example II

A polysulfone (PSO), which was commercially available from Union Carbide Company under the trademark Udel P-1700 and having a melt viscosity at 350°C or 5,600 poise, was blended with varying amounts of PPS the PPS and the PEEK as described in Example I. The results of the tests on the blends are presented in Table II:

Table II

Run No.	1	8	10	12	13	14	15	16
PPS, Wt. %	100	0	50	50	50	50	0	50
PEEK, Wt. %	0	100	50	25	35	40	0	0
PSO, Wt. %	0	0	0	25	15	10	100	50
Heat Distortion Temp, F	117	164	154	161	160	160	165	103
Flexural Modulus, MPa	3455	3499	3748	3593	3687	3620	2515	3373
Flexural Strength, MPa	148	164	166	152	160	160	115	143
Tensile Strength								
Break, MPa	85.6	107	97.5	89.1	91.9	94.3	65.8	86.3
Elongation, %	3.4	39.2	9.0	3.0	2.7	7.6	51.2	2.8
Izod Impact, J/M								
inch of notch	44.2	61.2	44.8	31.4	30.0	31.4	80	32.4
Izod Impact, no notch J/M	293	3756	1096	332	511	530	3672	655

The data in Table II show that the homogeneous ternary blends (Runs 12-14) have a higher heat distortion temperature than the original PPS (Run 1) and the 50/50 blend of PPS and PSO (Run 16). In addition, the homogeneous ternary blends (Runs 12-14) exhibit a higher heat distortion temperature (HDT) than does a 50/50 blend of PPS and PEEK (Run 10). For example, the HDT value is 154°F for Run 10 (a blend of 50% PPS and 50% PEEK), as compared to the HDT value of 161°F for Run 12, (a blend of 50% PPS, 25% PEEK, and 25% PSO).

Example III

A polyamide-imide (PAI), which was commercially available from Amoco Chemicals under the tradename Torlon 4203E® and having Tg 275°C and a processing temperature range 600-675°F, was blended with varying amounts of the PPS and the PEEK as described in Example I. The results of the tests on the blends are presented in Table III.

Table III

Run No.	1	8	10	16	17	18
PPS, Wt. %	100	0	50	50	50	50
PEEK, Wt. %	0	100	50	25	35	40
PAI, Wt. %	0	0	0	25	15	10
Heat Distortion Temp, F	117	164	154	171	160	160
Flexural Modulus, MPa	3455	3499	3748	3917	3899	4047
Flexural Strength, MPa	148	164	166	81.5; 76.4	100	114
Tensile Strength Break, MPa	85.6	107	97.5	39.0	68.9; 66.8	83.1; 74.4
Elongation, %	3.4	39.2	9.0	0.6	1.4	1.7
Izod Impact, notched, J/M	44.2	61.2	44.8	30.1	32.0	31.4
Izod Impact, unnotched, J/M	293	3756	1096	92.5	174	210

The data in Table III show that homogenous ternary blends (Runs 16-18) have a higher heat distortion temperature than the original PPS (Run 1) and blend of PPS and PEEK (Run 10). The data further show that homogenous ternary blends (Runs 16-18) have greater flexural modulus than the original PPS (Run 1), original PEEK (Run 8) and the blend of PPS and PEEK (Run 10).

The disclosure, including data, has illustrated the value and effectiveness of our invention. The examples, the knowledge and background of the field of the invention and the general principles of chemistry and of other applicable sciences have formed the bases from the the broad descriptions of our invention including the ranges of conditions and the generic groups of operant components have been developed, and formed the bases for our claims here appended.

Claims

1. A polymer composition comprising:

(a) a poly(arylene sulfide);

(b) a poly(amide imide); and

(c) at least one of a poly(aryl ketone) and a poly(aryl sulfone).

2. The composition of claim 1, wherein said (c) is a said poly(aryl ketone).

3. The composition of claim 1 or 2, employing about 10 to 90 weight percent said (a);
about 5 to 40 weight percent said (b); and

about 5 to 80 weight percent said (c);

such that the total of (a) + (b) + (c) is 100.

4. The polymer composition of claim 1, 2 or 3, further including a fiber reinforcing material in an amount of about 20 to 50 weight percent, based on the weight of the polymers in the composition, in particular wherein the fiber reinforcing material is selected from glass fibers and carbon fibers.

5. The composition of one of the preceding claims, wherein said (a) is poly(phenylene sulfide), and said (c) is poly ether ether ketone.

6. The composition of one of the preceding claims wherein said (c) is said poly(aryl ketone) plus said poly(aryl sulfone).

7. The composition of claim 6, employing about 10 to 90 weight percent said (a);

about 5 to 50 weight percent said (b); and

about 5 to 80 weight percent of each of said poly(aryl) ketone and said poly(aryl sulfone), such that the total of all components is 100.

8. The composition of one of the preceding claims, wherein said (a) is poly(phenylene sulfide), and said (c) is poly ether ether ketone and polyether sulfone.

(19)



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(54) Poly(arylene sulfide) resin ternary blends.

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European Patent
Office

EUROPEAN SEARCH REPORT

Application Number

EP 87 10 5219

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.4)
X	EP-A-0 166 450 (UNION CARBIDE CORP.) * Claims 1-9; page 12, last paragraph - page 13, line 2 *	1-5	C 08 L 81/02 C 08 L 79/02 C 08 L 71/00 C 08 L 81/06
P,X	WO-A-8 607 599 (AMOCO CORP.) * Claims 1-7; page 16, paragraph 2,3 *	1,4,5,6 ,8	
A	US-A-4 340 697 (AYAS et al.) * Claims 1,4; column 8, lines 24-35; column 9, line 51 - column 10, line 66; column 17, paragraph 2 *	1,4	
A	US-A-4 528 346 (SUGIE et al.) * Claims 1,4; column 6, line 62 - column 11, line 10; column 15, lines 38-41 *	1,4,6,8	
			TECHNICAL FIELDS SEARCHED (Int. Cl.4)
			C 08 L
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 25-05-1988	Examiner VOIGTLAENDER R.O.J.
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